

Work Order ID 75447

75447

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October-21-11 2:45:49 PM

Item ID: D3610-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 21/10/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 10/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3610	Rev A

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00 ok 12/02/03 6
 Jeaspa Bandsaw Cut blank 6.600 " long

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1- Mill as per Folio FA692 Rev: AA & Dwg D3610 Rev: A 2-Deburr per dwg D3610 ok/ok 12-01-04 (x6)

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 ok/ok 12-01-04 (x6)
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		12/21/15		6	6		
140 *140* Small Fab Small Fab	Small Fab Memo 1-C'SINK AS PER DWG D3610	0.00 0.00							12/02/06 (6)
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5/26/16		(46)			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:10	OVEN TEMPERATURE:							
	FINISH TIME: 3:20	1:40							
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
180									
Small Fab	Memo	0.00							
Small Fab	Rivet Nut Plate as per Dwg D3610								

6X0/M-12/02/06

6X0 12-2-6

6X0 12/02/07 (6)

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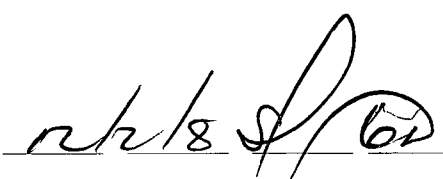
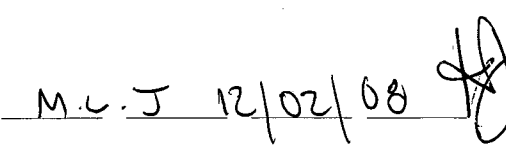
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>2YSA</u> Memo	0.00 0.00							
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

M.C.J 12/02/11


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NOTE: Date & initial all entries

Picklist Print

October-21-11 2:45:54 PM

Work Order ID: 75447

75447

Parent Item: D3610-041

D3610-041

Parent Item Name: Bracket

Start Date: 21/10/2011

Required Date: 10/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A new issue 07.03.28 EC
IPP rev B released, changed mat'l EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4140N- B1.500X1.5000		Purchased	No			100	f	0.0000	0.5775	3.465			
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M4140N-B1 500X1 5000

4140 Steel Bar 1.50 x 1.50

MS20426AD3-4		Purchased	No			110	Each	4,810.000	2	12			
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MS20426AD3-4

RIVET

4130 Steel Bar M119832 X 3.47' mk 12/02/03

**

EB 12/02/07

12

MS21075L3		Purchased	No			180	Each	90.0000	1	6			
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MS21075L3

Nutplate

**

EB 12/02/07

1

Location

ST316
104374
110398

Loc Qty

4810
1100
3710

Loc Code

Location

ST303
117677

Loc Qty

90
90

Loc Code

M120459 (52)

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 75447
Description: Bracket		Part Number: 03610-041
Inspection Dwg: 03610	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.50	+/- .030	6.501	✓		caliper	CNC-02
3.00	+/- .030	2.9815	✓		"	"
2.677	+/- .010	2.678	✓		"	"
0.38	+/- .010	0.3855	✓		"	"
1.25	+/- .030	1.247	✓		"	"
0.63	+/- .030	0.6245	✓		"	"
0.250	+/- .010	0.257	✓		"	"
Ø .201	+0.005 / -0.001	0.2015	✓		"	"
Ø .098	+0.004 / -0.001	.098	✓		"	"
Ø .277	+0.006 / -0.004	.277	✓		"	"
0.88	+/- .030	.874	✓		"	"
0.94	+/- .030	.936	✓		"	"
0.50	+/- .030	.499	✓		"	"
0.125	+/- .010	.119	✓		depth gauge	ML-05
.250	+/- .010	.251	✓		caliper	CNC-02

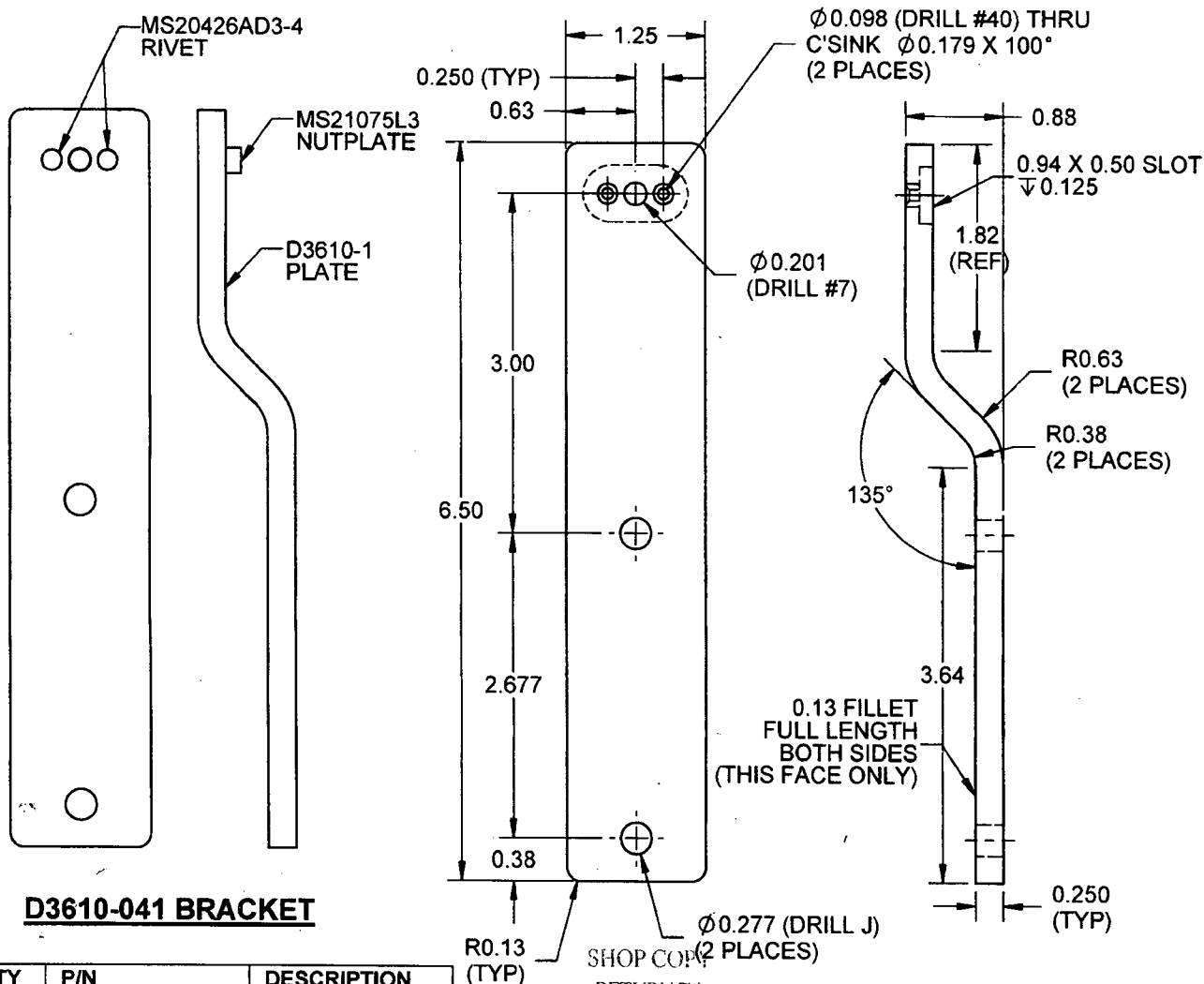
Measured by: JT/anz	Audited by: [Signature]	Preliminary Approval: _____
Date: 12-02-04	Date: 12/2/15	Date: _____

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3610	REV. A SHEET 1 OF 1
DATE 07.04.20	TITLE BRACKET		SCALE 2:3
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	



D3610-041 BRACKET

QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

D3610-041 NOTES:

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

D3610-1 NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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SUBJECT TO AMENDMENT

D3610-1 PLATE

RELEASED

WITHOUT NOTICE
WORK ORDER

NO. 75447 M.C.J

11/10/24

07.04.25

W/O:		WORK ORDER CHANGES					
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